Work Orde April-05-13 1:25	r ID 99395 5:07 PM		*993	395*	·					Page 1
Revision ID:	D3066-1	A	Accept	*N900)()4()	100)* s	etup Star Stop	1 11	S1* S2*
Start Date: Required Date: Reference:	4/04/13 Start Qty: 60.00 5/06/13 Req'd Qty: 60.00	*60* *60*	Community of the second	Cust Item Customer:						
Approvals:	Process Plan: 」	Date: 13-04-05	Tooling:		Date:		R	tun Star	171	R1*
••	QC:		SPC (Y/N):	D	Date:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3066	Rev B									
100			0.00				AØ6	8		
100 Waterjet FLOW CNC Waterje	FLOW WATER JET Memo t 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if	r Dwg D3066	0.00				_\$\$	O		<u>Jm13</u> -5-3
110	QC2- Inspect parts off n	nachine FAI/FAIB	0.00			P.	760	80		Jn 13-5-3
110 QC Quality_Control	Memo		0.00				NGQ Y	<u> </u>		JW12.2.2
					٠.					
120 *4.00*	QC8- Inspect parts - sec	ond check	0.00				(₂ %			
120 QC Quality Control	Memo		0.00 SS			(Low		· · - »	2

NCR: Y	es/	/ No				WORK ORDER NON-	100	NFORN	MANCE / UPDATE		QA Closed:	Date	:
Work Orde	er:					DISPOSITION			AGA	AINST DEF	PARTMENT	/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro Rec/Stor	Engineering Quality Other		
Root	 		[Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
				 .		······································	AUL	T CATE	GORY				
Landir		ear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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0.00

Memo

*** STOCK IN STEP CELL***

Packaging

Packaging

												DQA:	Date	e:	
NCR:	Yes /	' No				WORK ORDER NON-C		NFORM	MANCE / UP	DATE		_	_		
	 										Q	A Closed:	Date	e:	
Work Ord	or:					DISPOSITION				AGAINST DI	EP#	ARTMENT/	PROCESS		
WOIK OIG	CI					Rework	1		Skid-tube	Crosstube	٦	1	Water Jet	\neg	Engineering
Part f	No.					Scrap			Machining	Small Fab	\dashv	Proc	I. Eng. Coor.	ㅓ	Quality
1 4101	···.					Use-as-is			noforming	Finishing	1		e/Packaging	┪	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	,	Supplier	ヿ	
						· -	,								
Root		-			Descri	ption of work order update	1	nitial	Ac	tion	T	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
Doc/Data											1			İ	
Equip/Tooling															
Operator												Ċ			
Material	Ш														
Setup															
Other	Ш										İ				
Process	Ш														
Supplier	Ш										-	'			
Training															
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		<u> </u>				· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY				 		
Landi	ng Ge					General		٠:		<u> </u>	٦	valized	Г	\neg	Pressure/Forced .
		ending			0/6	Bend	-	Grain		<u> </u>	┥.	ovanzeo Over/Under	talaranaa		Temperature/Cure
			ot Concer	ntric to	^{0/5} -	BOM/Route	<u> </u>	Hardwa		-		art Incorrec	F	—	Weld
	 -	racks	^rimno-l		-	Broken/Damaged	\vdash	1	on Incomplete ions Incomplete/	/Uncloar		art incorrectart Lost/Mi			Wrong Stock Pulled
	<u> </u>	rusnea/(uffs	Crimped.		<u> </u>	Burrs	-	Mainte	•	Unclear	_	art Lost/IVIII art Moved	oonig [vviolig Stock rulled
	\vdash	uπs eat Trea			-	Contamination Countersink	-	Mislabe		· -	⊣`	art Moved ositioned W	Irona		
	\vdash			Tubo	-	┥	\vdash	Misread		-	_	ositioned w		—	Other
	ı jın	specuor	Strip in	rube	1	Cut Too Short	1	Liviisi EdC	ı	1	۱۲	OWEL FO22/	Juige	,	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Work Ord		9395		*99?				Page 3			
Item ID: Revision ID: Item Name:	D3066-1 Spacer			Accept	*N9000	740	100)*	Setup Start	171.	S1* S2*
Start Date: Required Date Reference:	4/04/13 e: 5/06/13	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust Item II Customer:) :					· · · · · · · · · · · · · · · · · · ·
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):	Date Date Date Date Date Date Date Date				Run Start Stop	"[7]	R1* R2*
Sequence ID/ Work Center 160 *160* QC Quality Control	ID	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty	Reject Number	Insp. Stamp

t .* . . .

											DQA:	Da1	te: ˌ	
NCR:	Yes	/ No				WORK ORDER NON-O	100	VFORN	MANCE / UP	DATE	QA Closed:	Da	te:	
						DISPOSITION				AGAINST DI	PARTMENT			ें पूर्व के क्षेत्रवर्षिक
	Part No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Small Fab Finishing	=	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other	
Root						otion of work order update	1	Initial		tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
						F.	AUL	T CATE	GORY			·····		
Landi -	_	Bending Centre No Cracks		ntric to (o/s	General Bend BOM/Route Broken/Damaged		4	on Incomplete		Ovalized Over/Under Part Incorre	ct		Pressure/Forced Temperature/Cure Weld
		Crushed/ Cuffs Heat Trea	•			Burrs Contamination Countersink		Mainte Mislabe		Unclear	Part Lost/M Part Moved Positioned	_		Wrong Stock Pulled
		Inspectio		Tube		Cut Too Short	 	Misread		1	Power Loss,	_		Other
		Ripples in	•			Drill Holes	\Box	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning'Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-05-13 1:25:06 PM

Work Order ID:

99395

Parent Item:

D3066-1

Parent Item Name: Spacer **Start Date:** 4/04/13

Required Date: 5/06/13

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:R Now M6061-T6 06-06-23 JLM

	IPP Kev:B	NOW MIGUOT-19 06	-06-23 JLN	/ 1									1
Component Item ID/ Item Name	Replaceme Item ID	ent Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	254.5600	0.0945	5,968422		-1 ^	
6061-T6 .080 Sheet									F 82	(G.C)		<u>JM13.</u>	<u> 3 </u>

<u>Location</u>	Loc Qty	Loc Code	
MAT021	254.560032		
117285	0.497264		
124786	254.062768		124786

NCR: Ye	es / No				WORK ORDER NON-	-CON	IFORN	MANCE / UPI	DATE			
•										QA Closed:	Date:	
Work Order	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No	-				Rework Scrap Use-as-is		I	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	0				Work Order Update			Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	I.	nitial		tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						ł						
Operator												
Material	_											
Setup	_											
Other	_											
Process	4									·		
Supplier				:		ļ						
Training	_											N
Unapproved											·	
						FAUL	CATE	GORY				
Landing				_	General	<u> </u>				7	. —	7. /-
1	Bending				Bend	\rightarrow	Grain		<u> </u>	Ovalized		Pressure/Forced
. -	Centre No	ot Concer	ntric to (o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under	_ —	Temperature/Cure
-	Cracks	_			Broken/Damaged			ion Incomplete		Part Incorre		Weld
-	Crushed/	Crimped.			Burrs	-		ions Incomplete/I	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
-	Cuffs			<u> </u>	Contamination	-	Mainte			Part Moved		
<u> </u>	Heat Trea				Countersink	\vdash	Mislabe		<u> </u>	Positioned V		٦٥٠٠
·	Inspection		Tube	<u> </u>	Cut Too Short		Misread	d	,	Power Loss/	Surge	Other
<u> </u>	Ripples in				Drill Holes	-	Offset		•			
_	Torque M			n	Drawing	-		Calibration				
İ	Turning S	equence		- 1	Finish		Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	99395
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

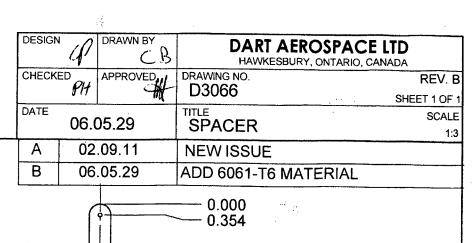
X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005	0.129"	-		V	Janoi
0.708	+/-0.010	0.701	-		V	
0.354	+/0.010	0.350"	_		ν	
0.354	+/0.010	0.351	-		V	
2.250 (Pitch)	+/-0.005	2.249"	_		V	
16.450	+/0.010	16.450"	-		Τ	Jemois
0.080	+/-0.010	0,078"			٧	
		•				
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				· · · · · · · · · · · · · · · · · · ·		

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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 13-5-3	Date: 1353	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	1
В	06.06.23	Dwg Rev. changed	KJ/JLM X	all.





2.600

RELEASED de 16.20 -#

> 4.850 7.100 9.350 \emptyset 0.128 (#30) (TYP 8 PLACES) 11.600 13.850 16.096 16.450 0.708 R0.354 (TYP) 0.354 -

D3066-1 SPACER

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

> 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES

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